



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE-350DAMPER Job Sheet 191523



Part No: RBE-350DAMPER

Job Qty: 4 pcs

Part Name: Damper Spanner Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *stk*

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
95	Large Fab - Welded Assy-1	4 pcs	4/18/19		0.00	1.00	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
100	QC 5	4 pcs	4/18/19		0.00	0.00	Large Fab - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
110	QC 9	4 pcs	4/18/19		0.00	0.00	QC 5 - 30	
							QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	

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					QC 9 - 50	
					QC 9 - 9	CL
115	Handfinish - 7-1-BeadBlast B4B	4 pcs	4/18/19	0.00 1.00	Handfinish - 7 - 1 - B4B	
					Handfinish - 7 - 2 - B4B	
120	Outsource - 12 - Black Oxide	4 pcs	4/18/19		GRO002-VC	10 JH 2019-06-05
125	Packaging 2-1 - Receive - B4B	4 pcs	4/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					126	QC 6
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
130	Packaging 3-1 - Stock - B4B	4 pcs	4/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

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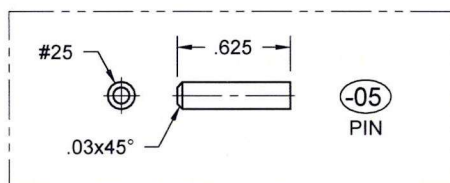
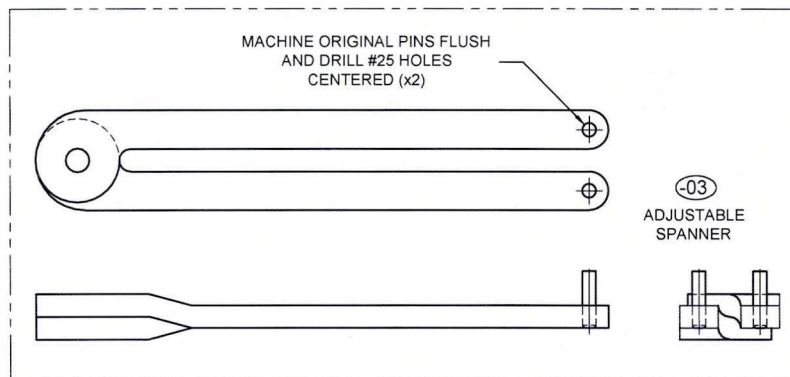
	Packaging 3 - 15 - B4B	
	Packaging 3 - 16 - B4B	
	Packaging 3 - 17 - B4B	
	Packaging 3 - 18 - B4B	
	Packaging 3 - 19 - B4B	
	Packaging 3 - 20 - B4B	
	Packaging 3 - 21 - B4B	
	Packaging 3 - 22 - B4B	
	Packaging 3 - 23 - B4B	
	Packaging 3 - 24 - B4B	
	Packaging 3 - 25 - B4B	
	Packaging 3 - 26 - B4B	
	Packaging 3 - 27 - B4B	
	Packaging 3 - 28 - B4B	
	Packaging 3 - 29 - B4B	
	Packaging 3 - 30 - B4B	
	Packaging 3 - 31 - B4B	
	Packaging 3 - 32 - B4B	
	Packaging 3 - 33 - B4B	
	Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	Damage	
Packaging 3 - 36 - B4B		
500 QC 21 - FG	4 pcs	4/18/19 0.00 0.00
	QC 21 - FG - 21	
	QC 21 - FG - 70	DAS
	QC 21 - SA - 53	21
Part Op 95 - (Weld per dwg A/R Steel rod Batch: _____), WELD AS PER DWG Descriptions: 100 - (QC5- Inspect part completeness to step on W/O) 110 - (QC9- Inspect visual per QSI004- Fusion Welds) 120 - -Issue P/O; PO <u>43647</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 125 - (Receive & Inspect for Damage & Mat'l Certs) 126 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____), Identify and Stock 500 - (QC21- Final Inspection - Work Order Release)		
Job BOM		
Part / Item	Component Name	Quantity
RBE-350DAMPER-03	Adjustable spanner	4 pcs (1 ea)
RBE-350DAMPER-05	Pin	8 pcs (2 ea)
		Operation
		95-Large Fab - Welded Assy-1
		95-Large Fab - Welded Assy-1
		Container
		5182660
		5182778
Job Allocations		
Operation	Component Part	Required
95-Large Fab - Welded Assy-1	RBE-350DAMPER-03	4
	RBE-350DAMPER-05	8
		Inventory
		0
		0
		Allocated
		0
		0
Part Specifications		
Specifications could not be found.		

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JUN 17 2019

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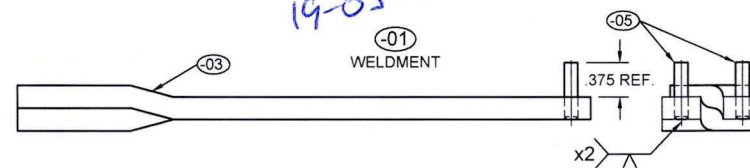
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/9/09	WP DW



SHOP COPY
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 191523 MJS
19-03-04



FUNCTION: USED TO REMOVE DAMPER CAP

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
	ASSY -01						

RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-9-09
SHEET 1 of 1	

DRAWN BY: PERRITT
APPROVED: *D. Weir*
HEAT TREAT: BLACK OXIDE
FINISH SPEC: USED ON MODEL
EUROCOPTER AS350/355

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S186939



Part: RBE-350DAMPER

Job No: 191523

Serial No/Batch: S186939

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Newkesbury, ON K8A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/04/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043647



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043647

PO Date: 6/5/19

Due Date: 6/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-06

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195146	RB6798927-1	Jaw Weldment Outside Processing - Black Oxide - Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54
2	195147	RB6798927-2	Crimper Jaw Weldment Outside Processing - Black Oxide - Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191523	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	7 pcs	0 pcs	7 pcs	\$3.636/pcs	\$25.45
				X7			JUN 11 2019		DAS 61 9-89	DP	
4	194416	RBST2162-11	Primary Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	13 pcs	0 pcs	13 pcs	\$3.636/pcs	\$47.27
				X13			JUN 11 2019			DP	
5	194270	RBE350A93-3201-00-23	Sleeve -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	6/12/19	5 pcs	0 pcs	5 pcs	\$3.636/pcs	\$18.18
Grand Total:											\$119.99

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/6/19 9:43 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(019787-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

019787- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Jun-2019		SVETLANA DORZHIYEVA		POHB043647				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6798927-1 Rev.	RB6798927-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0	0	0
2	RB679827-2 Rev. RB6798927-2	RB679827-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0	0	0
3	RBE-350DAMPER Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0
4	RBST2162-11 Rev.	RBST2162-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	13	13	0	0	0

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JUN 11 2019
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 JUN 11 2019
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.